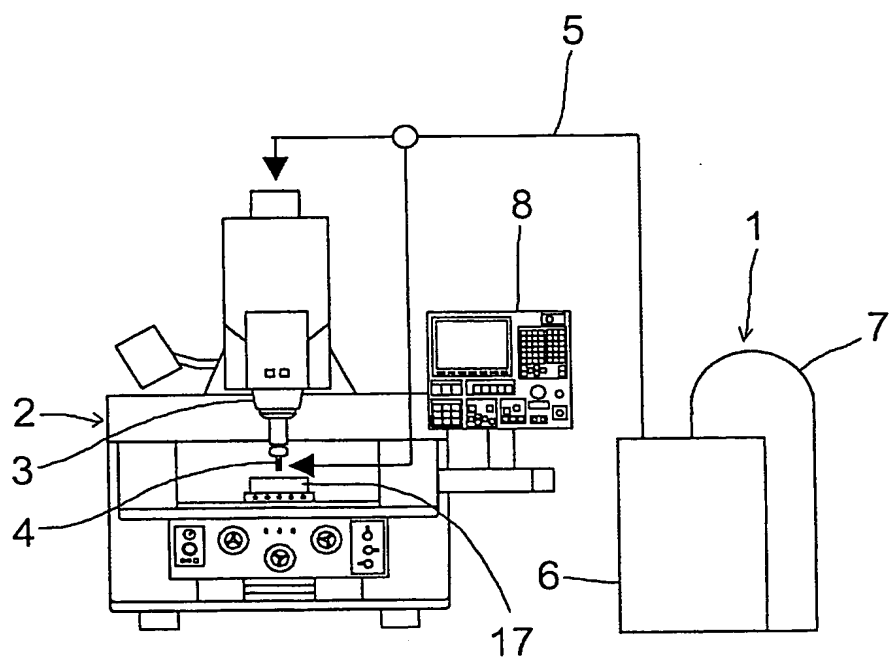
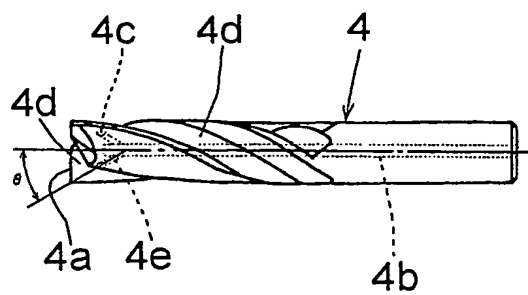


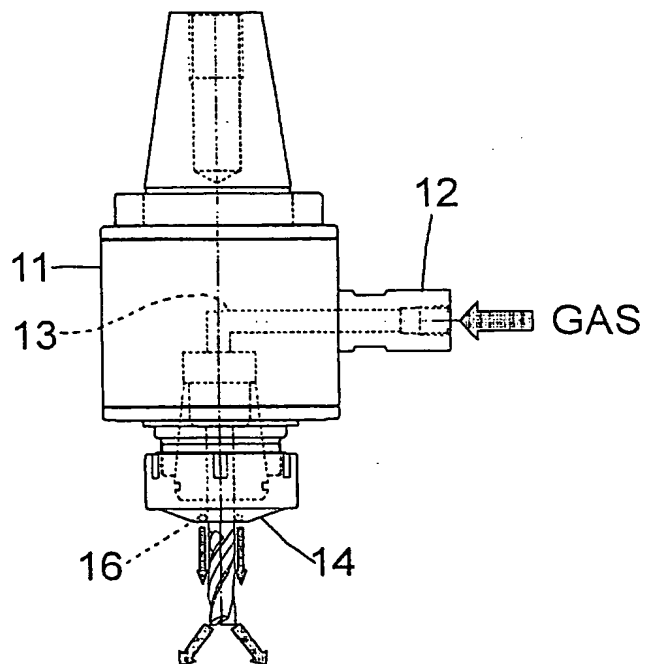
F I G. 1



F I G. 2



F I G. 3



F I G. 4

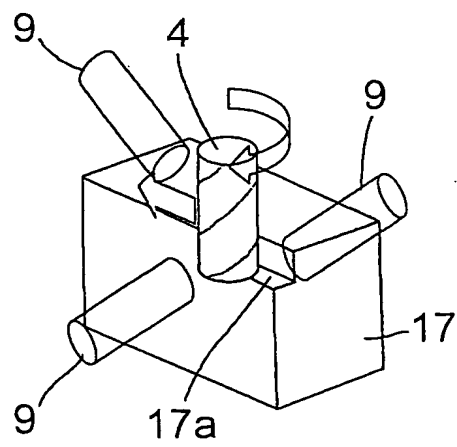
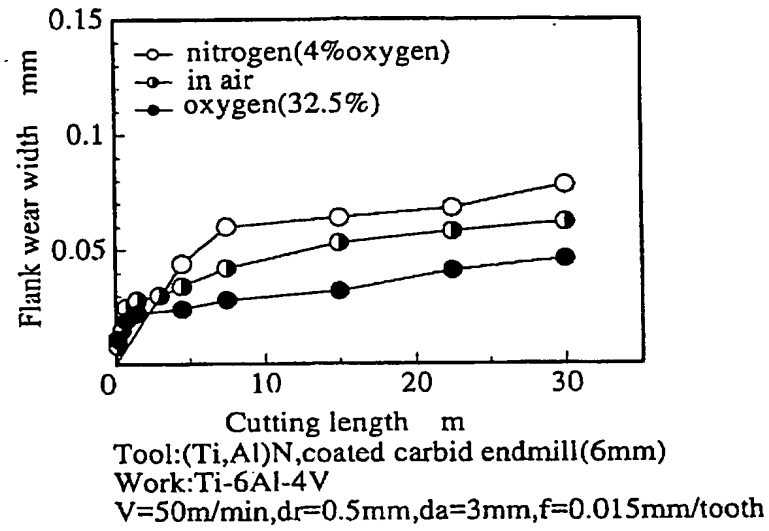


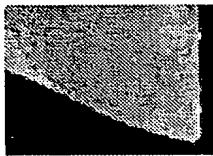
FIG. 5



# FIG. 6A

Nitrogen  
(4%O<sub>2</sub>)

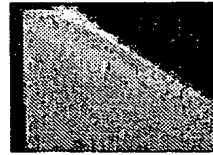
(a)



(b)



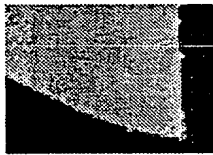
(c)



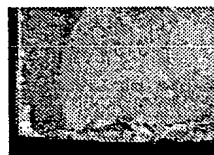
# FIG. 6B

Air  
(20.9%O<sub>2</sub>)

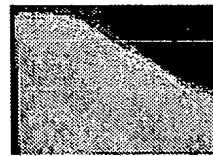
(a)



(b)



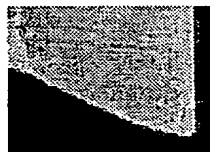
(c)



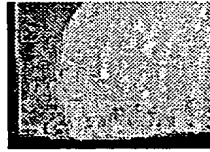
# FIG. 6C

Oxygen  
(32.5%O<sub>2</sub>)

(a)



(b)



(c)



Tool: (Ti,Al)N coated carbide end mill (  $\phi$  6mm)

Work: Ti-6Al-4V

V=50m/min, dr=0.5mm, da=3mm, f=0.015mm/tooth, L=30m

FIG. 7A

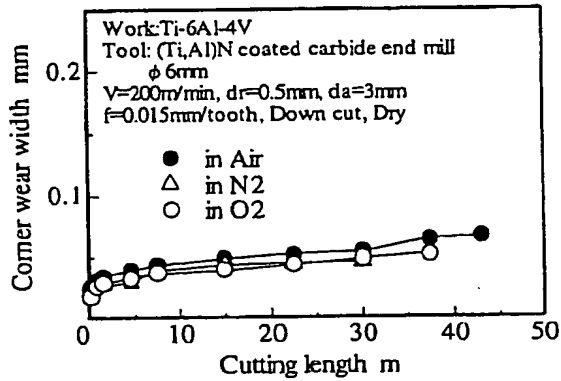


FIG. 7B

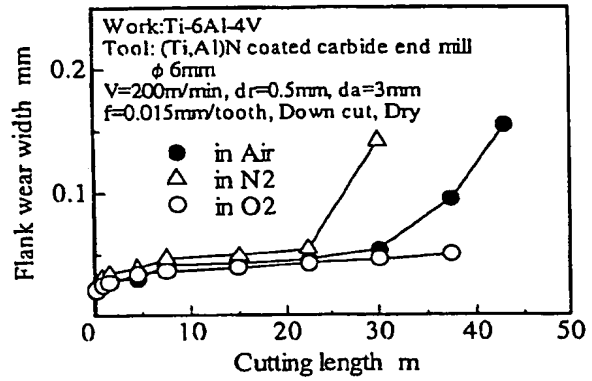


FIG. 8A

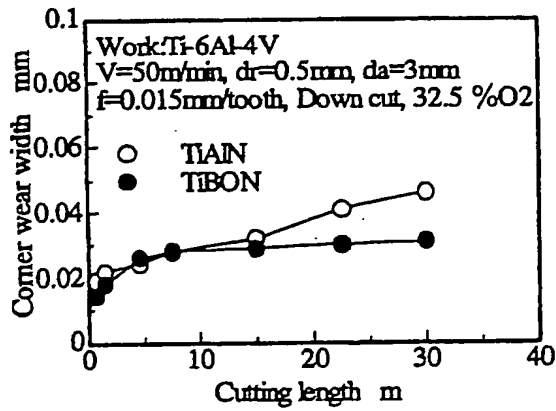


FIG. 8B

